



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2739
Job Sheet 169853



Part No: D2739

Job Qty: 10 ea

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28
As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/11/18	0.00	0.00	Start Up Skid tubes-2		
100	Skid tubes	10 pcs		1/11/18	0.00	5.41	Skid tubes-3		
120	HandFinish	10 pcs		1/12/18	0.00	0.83	HandFinish1		
130	QC	10 pcs		1/12/18	0.00	0.00	QC5		
140	Packaging	10 pcs		1/12/18	0.00	0.00	Packaging3-1		
150	QC21-SA	10 Ea		1/12/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
Descriptions: 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.
140 - LOCATION : LG002

JAN 19 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-5-108	10	130	0	0

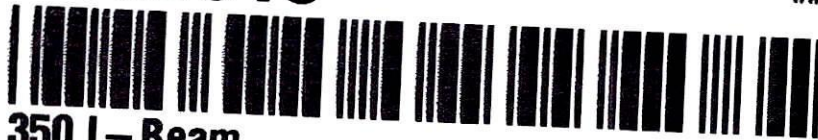
1X B112543 9X B145246

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100		



S032813



350 I-Beam

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

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PART NO: D2739
Original Serial #: S032813

Revision:

Operation:

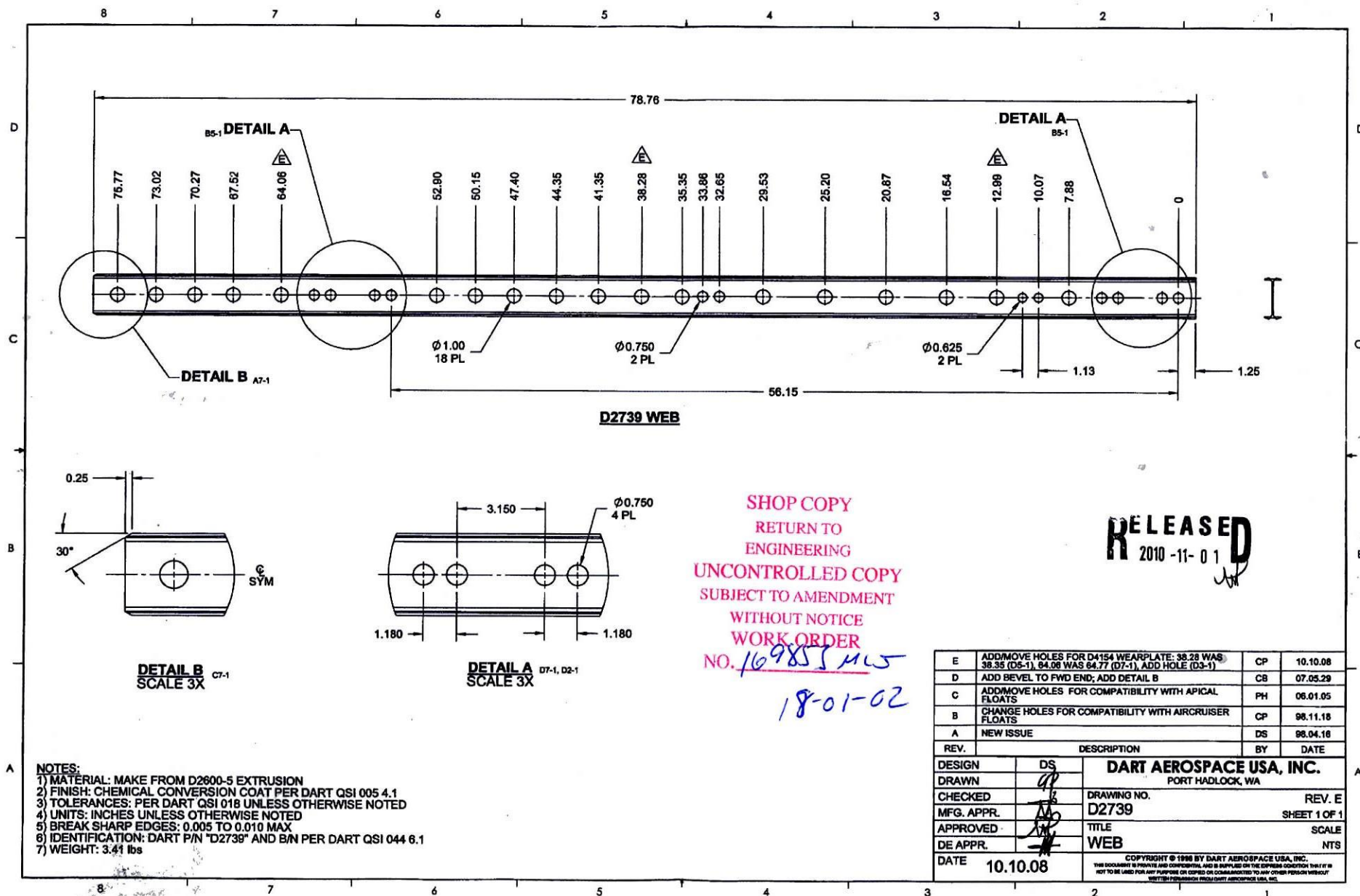
Change No:

Start up Operation 01/16/18

Job No: 169853

			10.040
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120

Plex 1/2/18 7:38 AM Dart.lajeunesse.marie



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 WORK ORDER
 NO. 169855 ML5
 18-01-02

RELEASED
 2010-11-01

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.00 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	C8	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2739 TITLE WEB SCALE NTS	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	REV. E SHEET 1 OF 1 DATE 10.10.08	
DATE	10.10.08		

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